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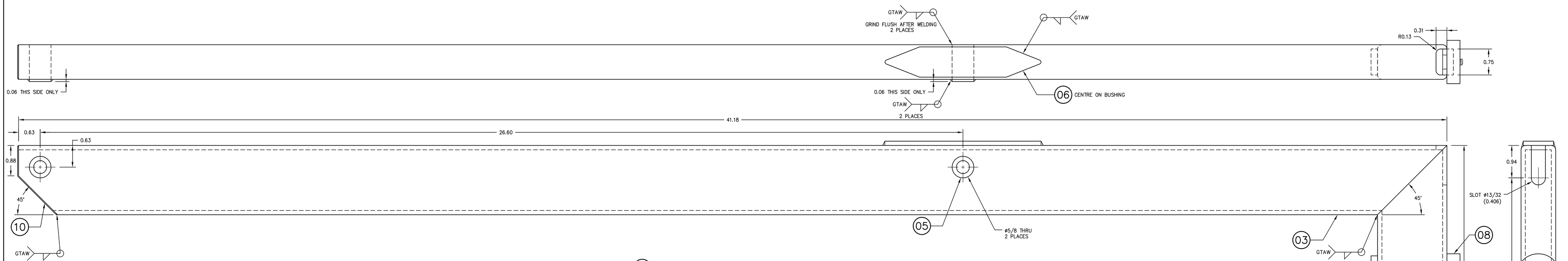
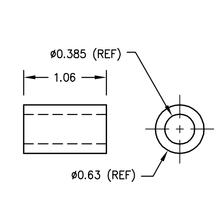
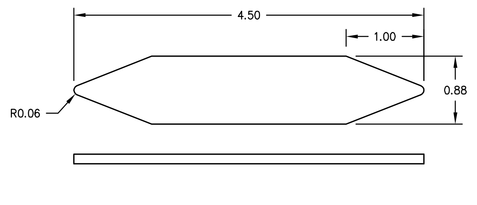
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	BEAM MODIFIED TO ACCOMODATE SLIDING DOOR	BJC	06/09/2006
2	BEAM MODIFIED FOR 2 KEYWAY ATTACHMENT	BJC	09/11/2006
3	KEYWAY ADDED FOR STEP INSTALLATION	BJC	15/07/2008
4	STOP (ITEM 12) DIMENSIONS UPDATED	BJC	15/11/2012
5	TITLE BLOCK UPDATED; SPRING MOVED TO NEW DWG; STRAP, BLOCK, CAP	BJC	19/11/2016
	MATERIALS UPDATED; ALUMINUM FINISH ADDED TO NOTE 3; NOTE 5 ADDED		



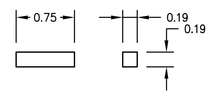
01 FORWARD BEAM ASSEMBLY
02 FORWARD BEAM ASSEMBLY



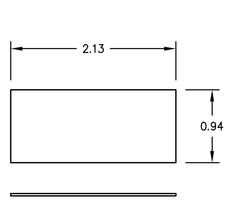
05 BUSHING



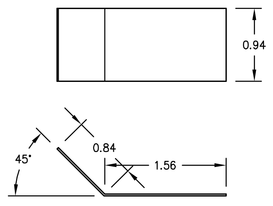
06 STRAP



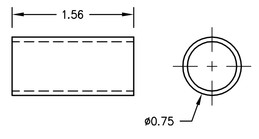
07 BLOCK



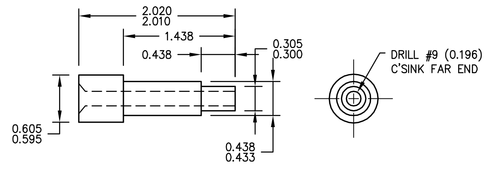
09 CAP



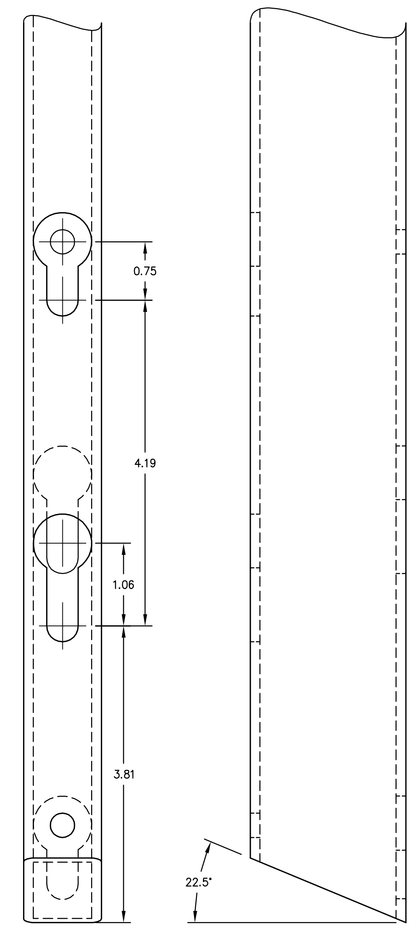
10 CAP

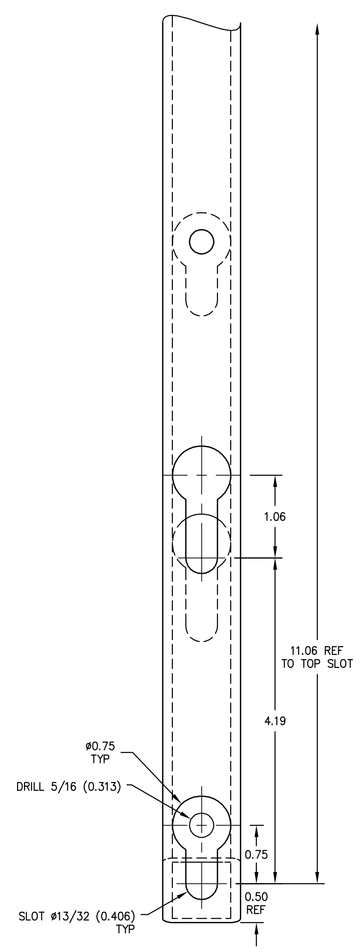


11 GUIDE

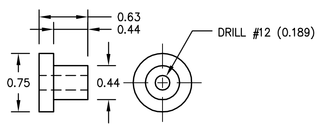


12 STOP

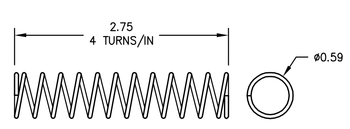




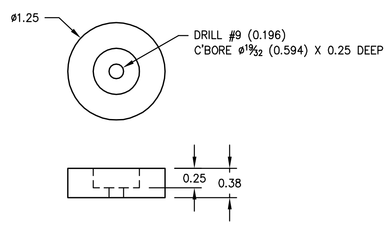
DETAIL A
LOOKING AT KEYWAY
PRIOR TO ASSEMBLY



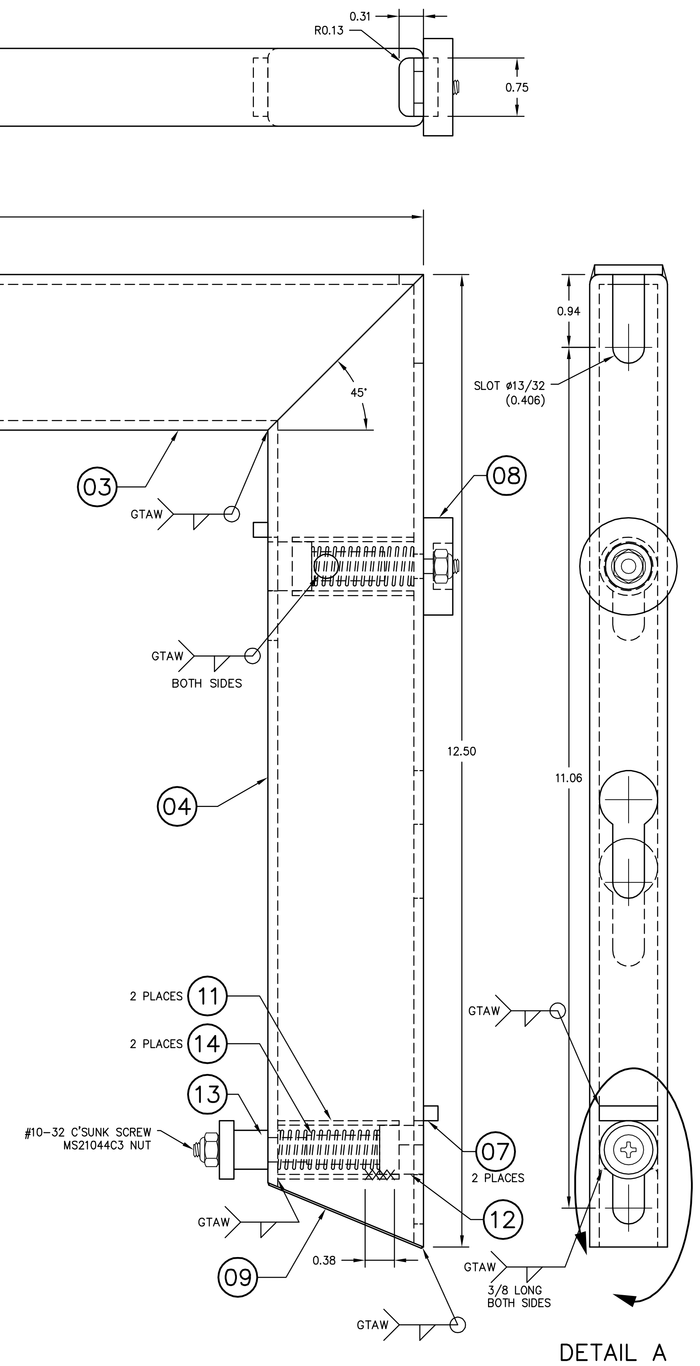
13 KNOB



14 SPRING
REFERENCE ONLY



08 KNOB



DETAIL A

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C.
   WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT FOR 4130/HSS STEEL.
   WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT FOR STAINLESS STEEL.
3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO INSTALLATION.
   ALTERNATE: ALL STEEL PARTS TO BE THOROUGHLY CLEANED, EPOXY PRIMED, AND POLYURETHANE PAINTED PRIOR TO INSTALLATION.
   ALL ALUMINUM PARTS TO BE ANODIZED IN ACCORDANCE WITH MIL-A-8625F, TYPE II.
4. FORWARD BEAM ASSEMBLY (69830-02) MAY BE USED AS A DIRECT REPLACEMENT FOR FORWARD BEAM ASSEMBLY (69830-01).
5. INBOARD STOWAGE PIN (UPPER POSITION) MAY BE OMITTED ON ASSEMBLY WHEN CABIN STEP IS NOT USED. PIN MAY BE INSTALLED IN THE FIELD AT TIME OF CABIN STEP INSTALLATION.

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
02	01			LIST OF MATERIALS – STEEL BEAM			
		69830-01	01	FORWARD BEAM ASSEMBLY			
		69830-02	02	FORWARD BEAM ASSEMBLY (STAINLESS STEEL)			
	1	69830-03	03	TUBE	HSS STEEL	CSA G40.21 50W	1 X 2 X 0.125 TUBE
1		69830-13	03	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
	1	69830-04	04	TUBE	HSS STEEL	CSA G40.21 50W	1 X 2 X 0.125 TUBE
1		69830-14	04	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
	2	69830-05	05	BUSHING	MILD STEEL	AISI 1010/1020	ø0.625 ROD
2		69830-15	05	BUSHING	304 STAINLESS STEEL	ASTM A213	ø0.625 X 0.120 TUBE
	1	69830-06	06	STRAP	4130 STEEL COND. N	MIL-S-18729	0.125 SHEET
		69830-16	06	STRAP	304 STAINLESS STEEL	AMS 5513	0.100-0.125 SHEET
1	1	69830-07	07	BLOCK	6061-T6 ALUMINUM	QQ-A-200/8	ø1.25 ROD
2	2	69830-08	08	KNOB	304 STAINLESS STEEL	ASTM A479	0.188 SQR. BAR ALT: 0.188 X 0.75 BAR
	1	69830-09	09	CAP	4130 STEEL COND. N	MIL-S-18729	0.025-0.050 SHEET
1		69830-19	09	CAP	304 STAINLESS STEEL	AMS 5513	0.025-0.050 SHEET
	1	69830-10	10	CAP	4130 STEEL COND. N	MIL-S-18729	0.025-0.050 SHEET
1		69830-20	10	CAP	304 STAINLESS STEEL	AMS 5513	0.025-0.050 SHEET
2	2	69830-11	11	GUIDE	304 STAINLESS STEEL	ASTM A269	ø0.75 X 0.065 RND. TUBE
2	2	69878-01	14	SPRING			
2	2	#10-32 X 3		C'SUNK SCREW	STAINLESS STEEL	COMMERCIAL	
1	1	69830-22	13	KNOB	6061-T6 ALUMINUM	QQ-A-200/8	ø0.75 ROD
2	2	69830-21	12	STOP	6061-T6 ALUMINUM	QQ-A-200/8	ø0.625 ROD
2	2	MS21044C3		NUT			

APPROVALS		DATE
DRAWN:	JEFF CLARKE	06 APR 2006
CHECKED:	E. BURGOIN	03 MAY 2006

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
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BELL 206L / 407
QUICK RELEASE CARGO BASKET
FORWARD BEAM FABRICATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A0	69830	5